

Work Order ID 161502

Tuesday, May 16, 2017 2:33:20 PM

161502

Page 1

Item ID: D3969-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spring (Basket Lid)
Start Date: 5/16/2017 Start Qty: 14.00 ***14*** Cust Item ID:
Required Date: 5/23/2017 Req'd Qty: 14.00 ***14*** Customer:
Reference: SCHEDULED

Approvals: Process Plan: DAS 21 Date: MAY 16 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3969	D								
100		0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>36364</u>								
	Order as per Dwg D3969								
	Possible supplier: LS Technologies								
	part#: SSA4/8-122-310-360N								
	Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.28							
Packaging	***Measure compression only at 5mm on gas spring***								

14 MAY 18 2017 DAS 13 9-89

14x SP 17-5-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC6- All purchased or subcontracted products Memo ***Measure compression only at 5mm on gas spring***	0.00 0.28				14			DAS 38 9-88 MAY 26 2017
122 *122* Small Fab Small Fab	CRIMP END FITTING AT LOCATION SHOWN ON DWG (SEE NOTE 8) ***IF NOT MADE BY VENDOR***	0.00 1.12							DAS 38 9-88
124 *124* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.28							DAS 38 9-88

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
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Past Expiry Date ☐	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified ☐	☐	Past Due	☐				

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Start Date: 5/16/2017 Start Qty: 14.00 ***14*** Cust Item ID:
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Reference: SCHEDULED

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: 51364	0.00							
130									
Packaging	Memo	0.14				14		DAS 6	
Packaging						MAY 30 2017		9-89	
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	1.40							
Quality Control									17/5/31 

DAS
21
9-89

MAY 30 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By 		
							Lead hand / Supervisor Approval Verification 		
QC / QA Coordinator Approval 									

Root Cause				FAULT CATEGORY			
☐ Environment	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
☐ Design	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
☐ Doc/Data	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
☐ Equip/Tooling	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
☐ Handling/Pre	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
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☐ Substation	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
☐ Past Expiry Date	☐ Manufacturing Process	OTHER : _____					
☐ Misidentified	☐ Past Due						

Picklist Print

Tuesday, May 16, 2017 2:33:23 PM

Page 1

Work Order ID: 161502

Parent Item: D3969-3

Parent Item Name: Spring (Basket Lid)

Start Date: 5/16/2017

Required Date: 5/23/2017

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
10.03.16 verified by:EC

IPP Rev:B as per revC DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
SSA4/8-122-310-360N Gas Spring		Purchased	No			110	Each	0.0000	1	14			

14 x 8017-5-25.

DQA: _____ Date: _____



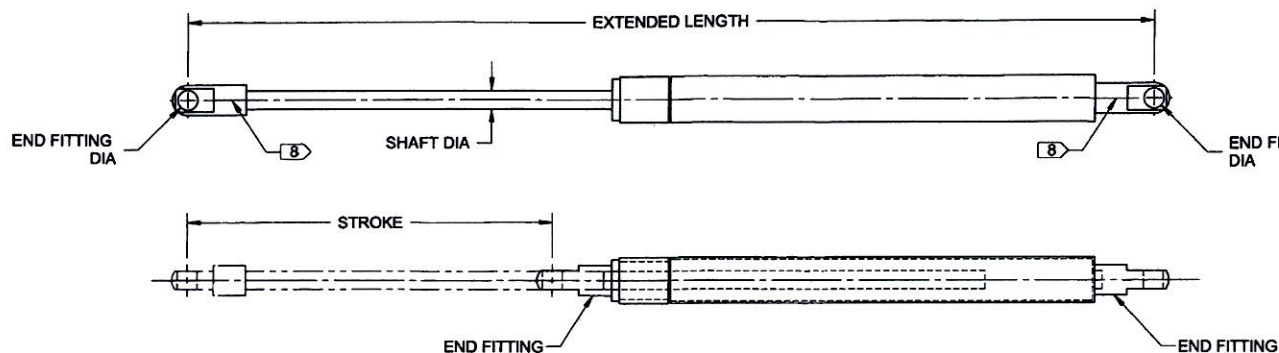
WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
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								Lead hand / Supervisor Approval Verification	
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Root Cause		FAULT CATEGORY							
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SPECIFICATION CONTROL DRAWING



SHOP COPY
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ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 161502
MLJ
1705-16

DART PART NUMBER	STROKE (mm/in)	EXTENDED LENGTH (mm/in)	SHAFT DIA (mm/in)	FORCE (N/lbs)	END FITTING TYPE	END FITTING DIA (in)	CASING MATERIAL	PREFERRED SUPPLIER	SUPPLIER PART NUMBER	WEIGHT APPROX
D3969-1	122/4.80	315/12.40	6/0.24	310/69.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-310N	0.27 lbs
D3969-3	122/4.80	315/12.40	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-122-310-360N	0.32 lbs
D3969-5	122/4.80	315/12.40	6/0.24	133/29.7	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-133N	0.27 lbs
D3969-7	122/4.80	315/12.40	6/0.24	222/50.0	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/6-122-315-225N	0.27 lbs
D3969-9	130/5.12	343/13.50	8/0.31	360/80.9	BLADE	0.257	STAINLESS STEEL	LS TECHNOLOGIES	SSA4/8-130-343-360N	0.35 lbs

NOTES:

- 1) MATERIAL: SEE CHART
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3969-X" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: SEE CHART
- 8) CRIMP END FITTING AT APPROXIMATE LOCATION SHOWN, PER MANUFACTURERS REQUIREMENTS

D	ADDED -7/-9	ML	16.05.12
C	REDRAWN IN SW. ADDED -3 & -5; ADDED SHAFT DIA COLUMN TO CHART. FORCE FOR -1 CORRECTED (WAS 60.0 lbs).	JPH	10.03.04
B	DRAWING RENAMED WAS: GAS SPRING (BASKET LID). NOTE 8 ADDED.	AJS	09.11.10
A	NEW ISSUE	AJS	09.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	DD	D3969	SHEET 1 OF 1
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	BASKET LID SPRING	NTS
DATE	16.05.12	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2016-05-19
B/L-581

APPROVED

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO36364

Purchase Order Date 5/18/2017
PO Print Date 5/18/2017

Page Number 1 of 2

Order From :

VC-LST0001

Ship To : DART AEROSPACE LTD

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA



Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms

Net 30

Currency

CAD

FOB

EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable CD Promise Date	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6/15-164/50-115N AS PER DWG D2807-041 REV. E B161458	Gas Spring	5/25/2017 Yes 5/25/2017	6.00 Each	\$63.90	\$383.40
Line Total:						\$383.40
2	SSA4/8-122-310-360N AS PER DWG D3969-3 REV. D B161502	Gas Spring ✓	5/25/2017 Yes 5/25/2017	14.00 Each	\$65.00	\$910.00
Line Total:						\$910.00
3	B6-167-410-070N AS PER DWG D3552-21 REV. L B161462	Gas Spring	5/25/2017 Yes 5/25/2017	6.00 Each	\$26.50	\$159.00

SP175-25

DAS
38
9-89

PO Instructions: Fedex Acc#151793240

Note:

5/18/2017

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
36364	5/23/2017	16638

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
5/23/2017	Fed-Ex	

Qty	Description
6	D2807-041 B161458 Stainless Gas Spring (6/15-164/50-115N)
14	D3969-3 B161502 Stainless Gas Spring (SSA4/8-122-310-360N) LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS
6	D3552-21 B161462 Gas Spring (B6-167-410-070N)
Shipping Via FED EX - Overnight - Tracking # 779209320201	

SP17-5-25

Order checked by :

DAS
38
9-89



LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

May 23, 2017

This is to certify that the parts listed below meets specifications as required by your order.

6 Units : D2807-041 B161458 Stainless Gas Spring

✓ 14 Units : D3969-3 B161502 Stainless Gas Spring
✓ LABELLED WITH PERMANT INK MARKER ONLY - NO LABELS

6 Units: D3552-21 B161462 Gas Spring

Country of Manufacture : Canada
Date of Manufacture : May 2017
This product is ROHS compliant.

Purchase Order # **36364**
Inv# **16638**

L S Technologies Inc Canada

A handwritten signature in black ink, appearing to be 'Nolan Fehr', written over a horizontal line.

Nolan Fehr
President